

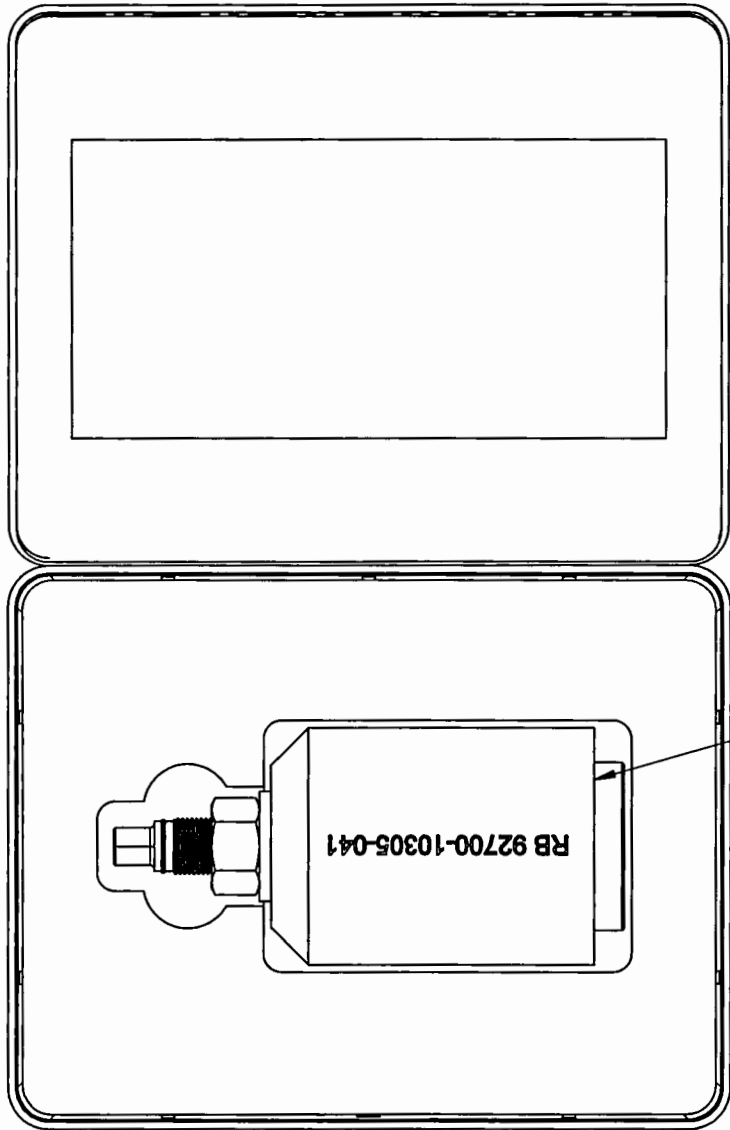
ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10305-041-1	PACKAGING ASSY
-4	1	RB 92700-10305-041-4	TGB & IGB SEAL INSTALLER ASSY
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.

D

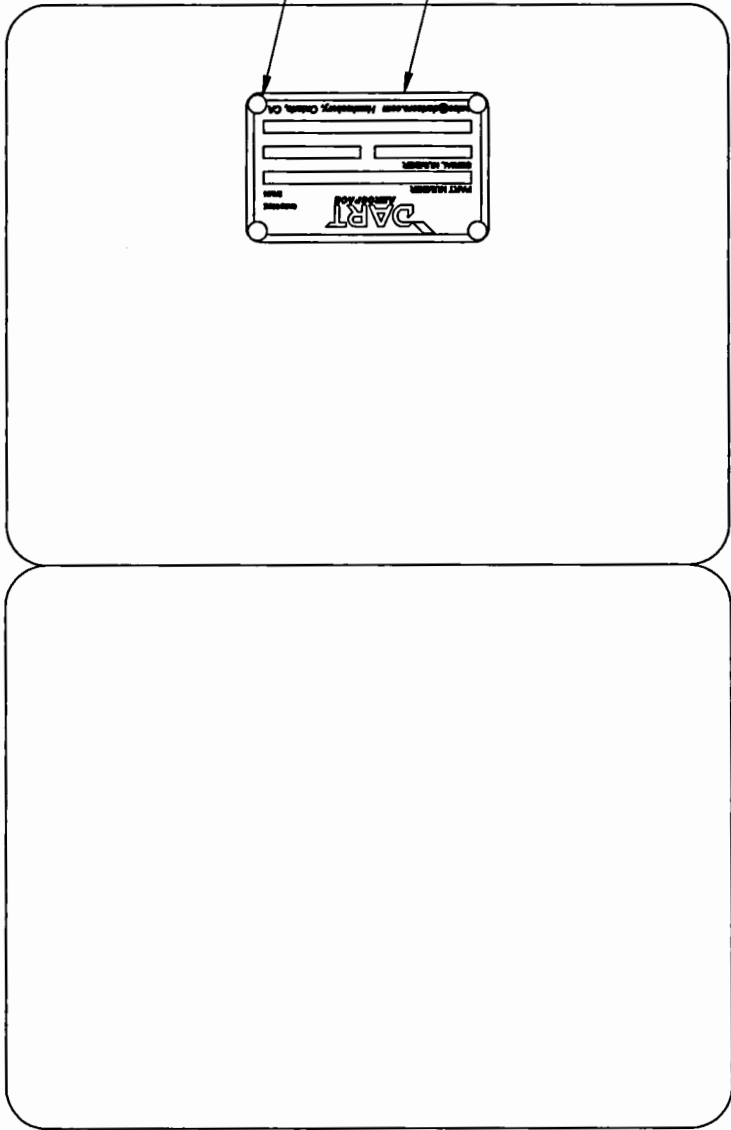
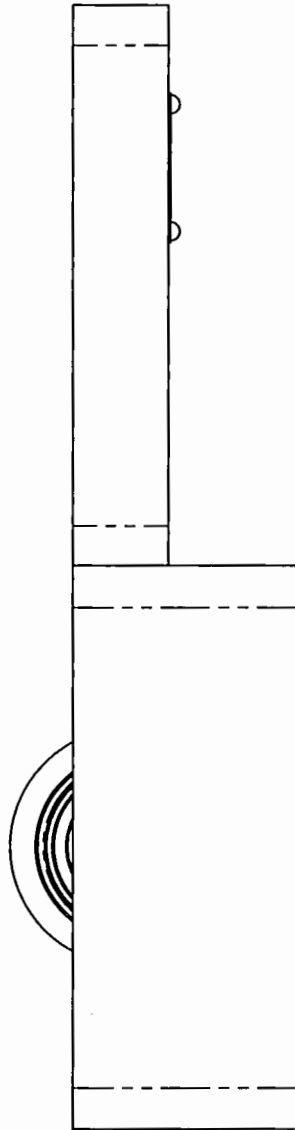
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NOTES:

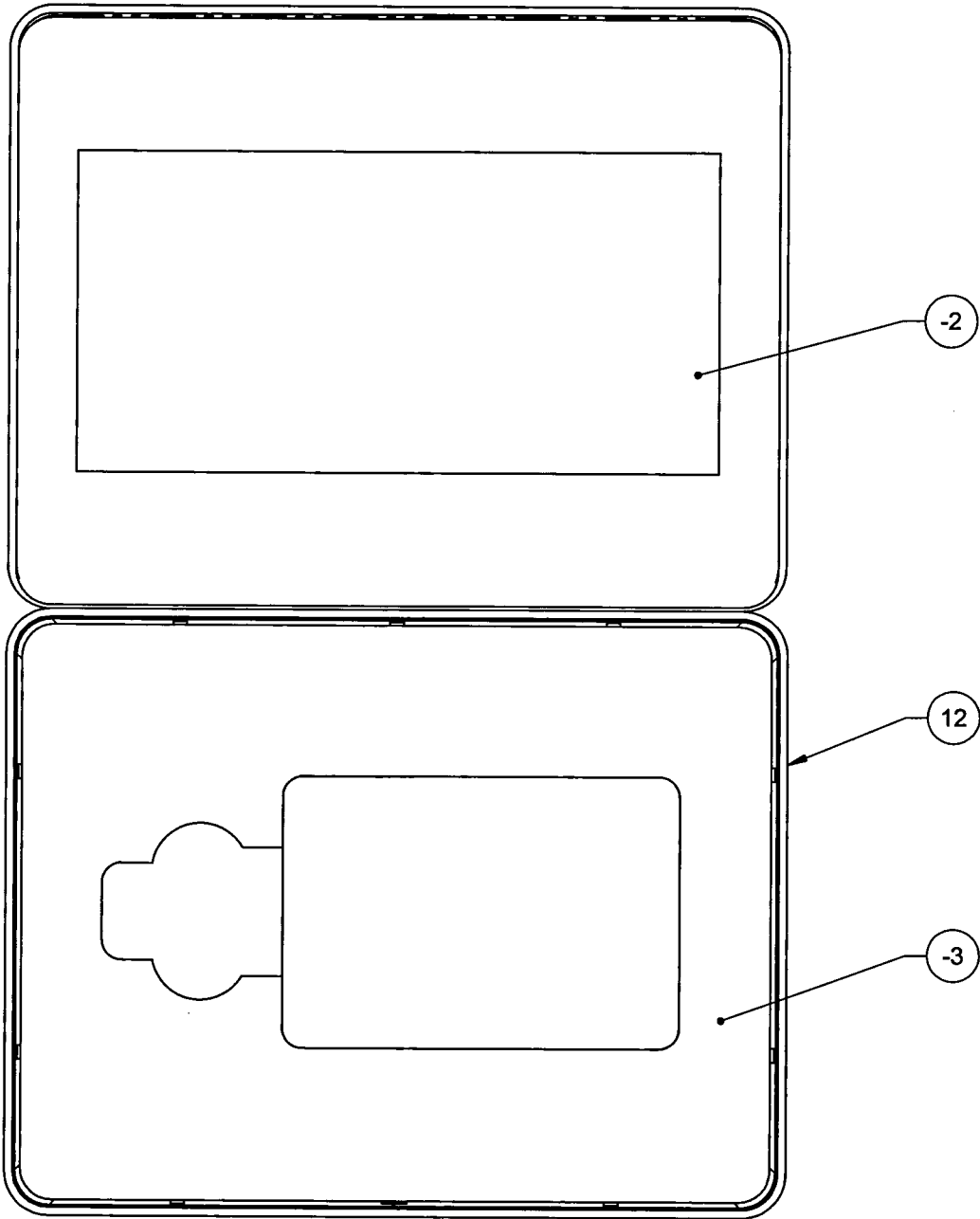
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

RB 92700-10305-041 TGB & IGB SEAL INSTALLER

UNDER REVIEW
ECR: ECR 426

A	NEW ISSUE	18-800	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 1 OF 10
APPROVED	VM	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10305-041-2	TOP FOAM
-3	1	RB 92700-10305-041-3	BOTTOM FOAM
12	1	PELICAN #APP-1200-E	PELICAN CASE 1200



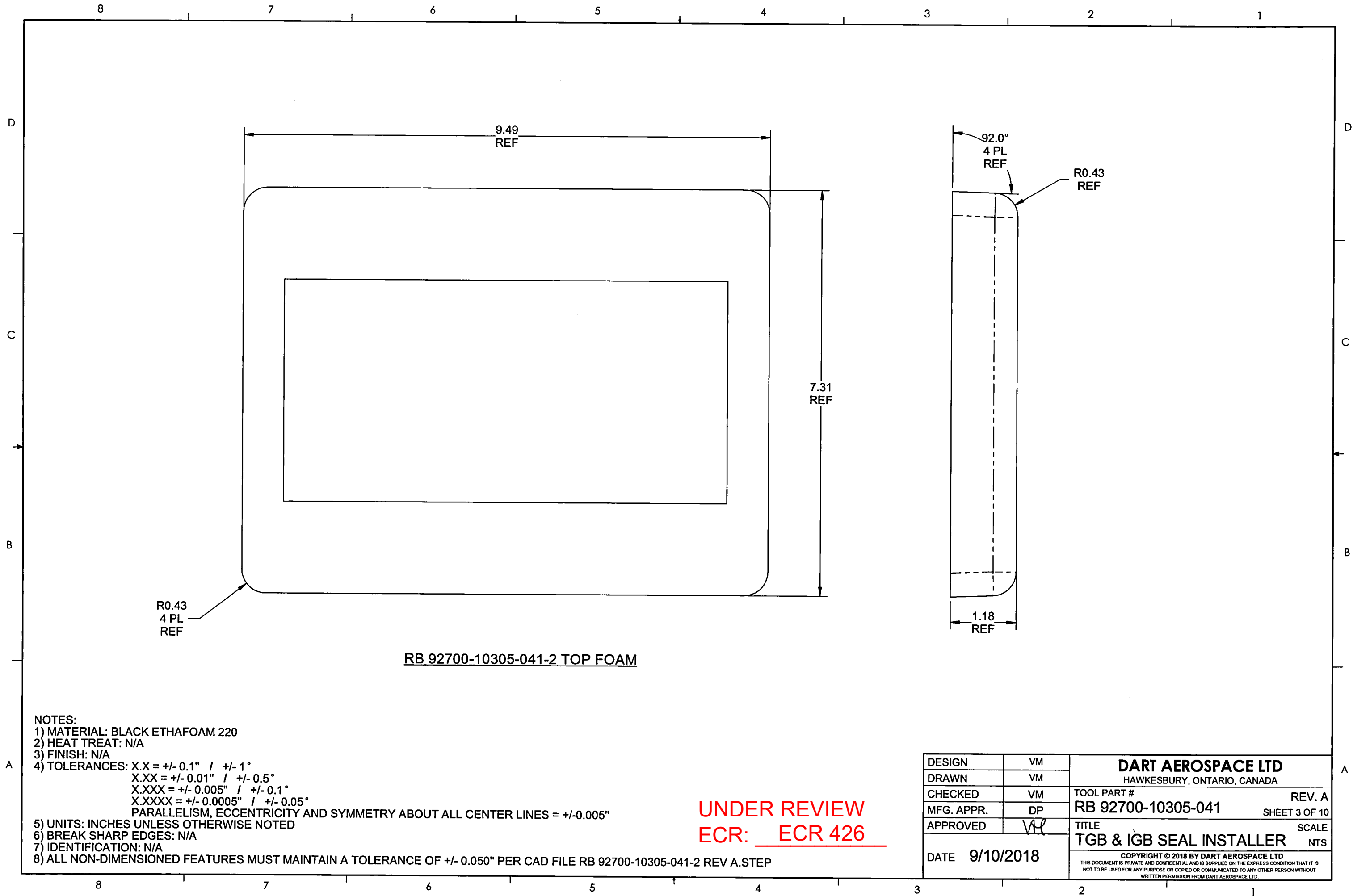
RB 92700-10305-041-1 PACKAGING ASSY

NOTES:

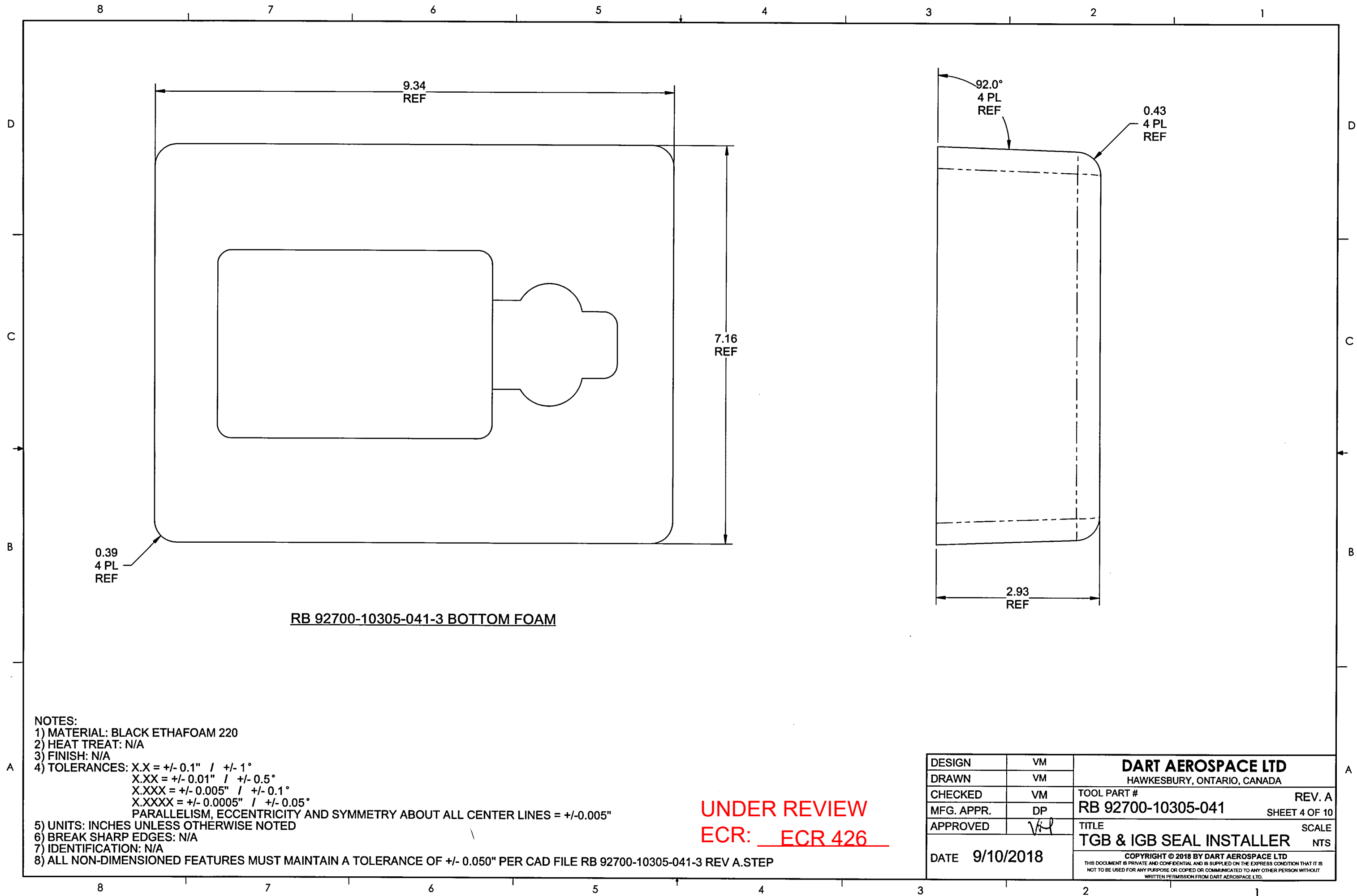
- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

UNDER REVIEW
ECR: ECR 426

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 2 OF 10
APPROVED	VP	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 3 OF 10
APPROVED	VM	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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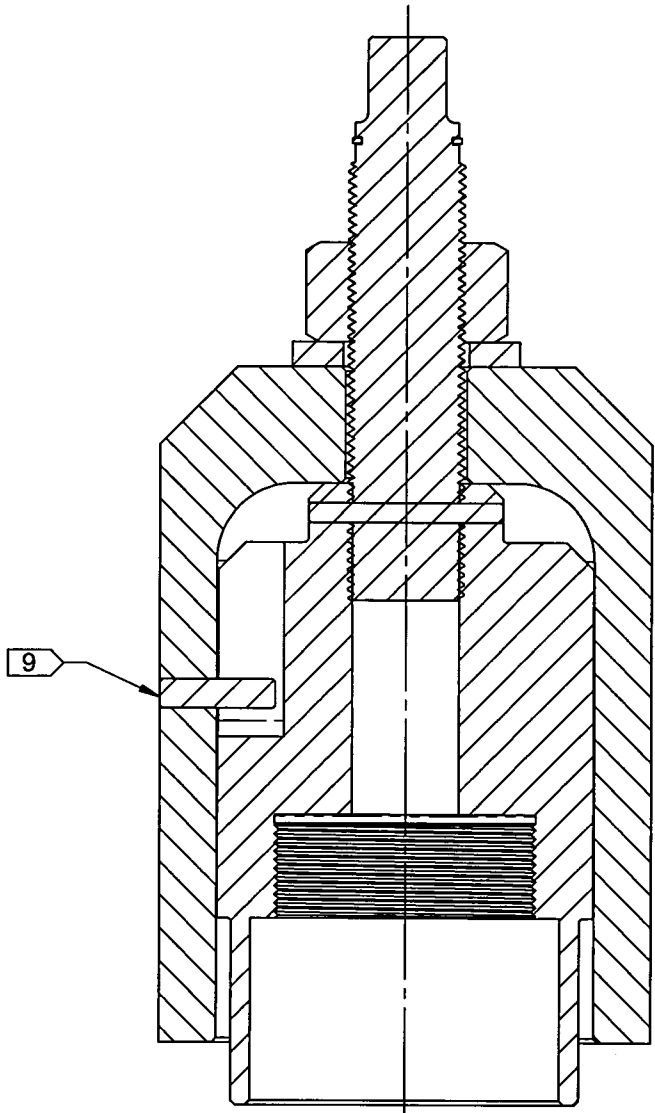
RB 92700-10305-041-3 BOTTOM FOAM

NOTES:
1) MATERIAL: BLACK ETHAFOAM 220
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10305-041-3 REV A.STEP

UNDER REVIEW
ECR: ECR 426

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 4 OF 10
APPROVED	VH	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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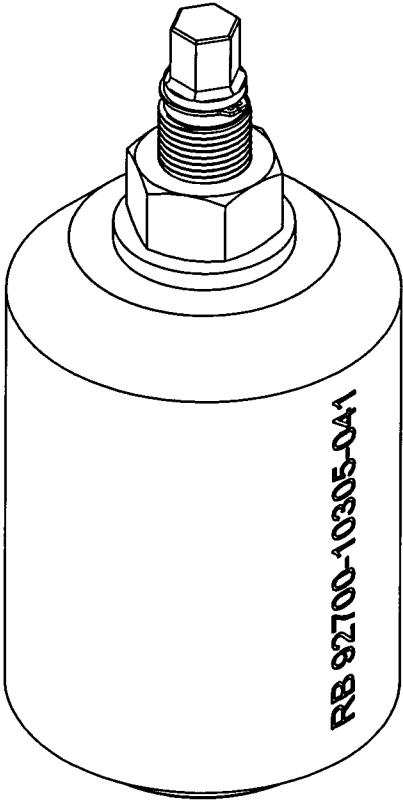
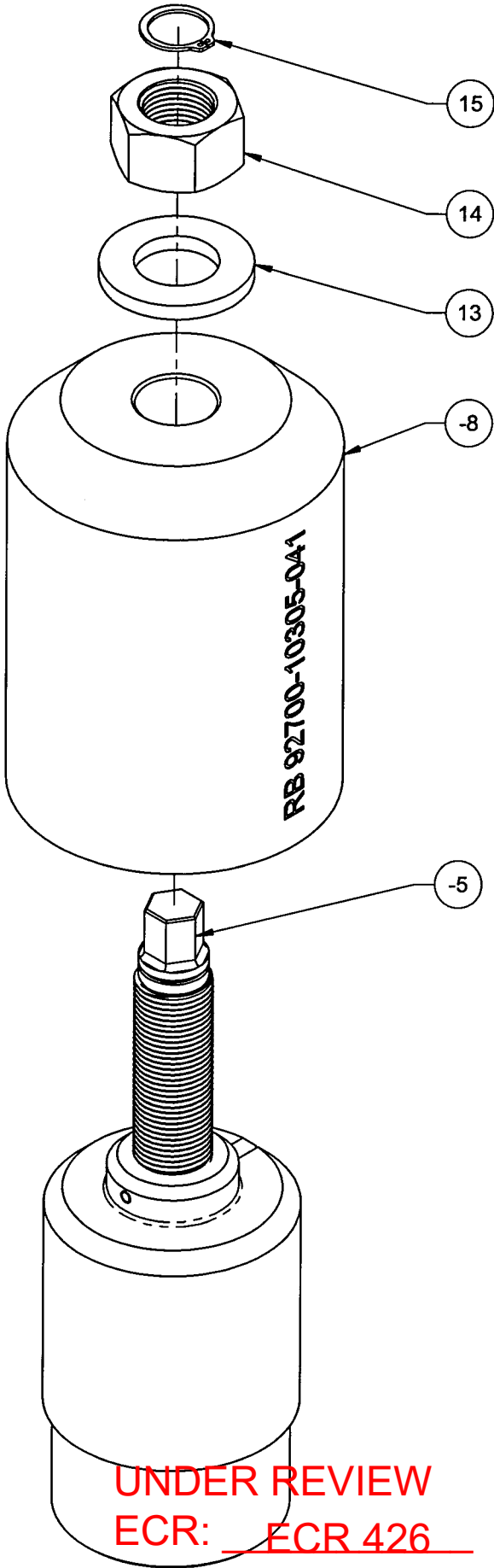
ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10305-041-5	PUSHER ASSY
-8	1	RB 92700-10305-041-8	REACTOR ASSY
13	1	McMaster#98023A036 OR EQUIV	STEEL FLAT WASHER FOR 3/4" SCREW
14	1	McMaster#94895A840 OR EQUIV	STEEL HEX NUT 3/4"-16
15	1	McMaster#98410A126 OR EQUIV	STEEL EXTERNAL RETAINING RING FOR 5/8" OD



RB 92700-10305-041-4 TGB & IGB SEAL INSTALLER ASSY

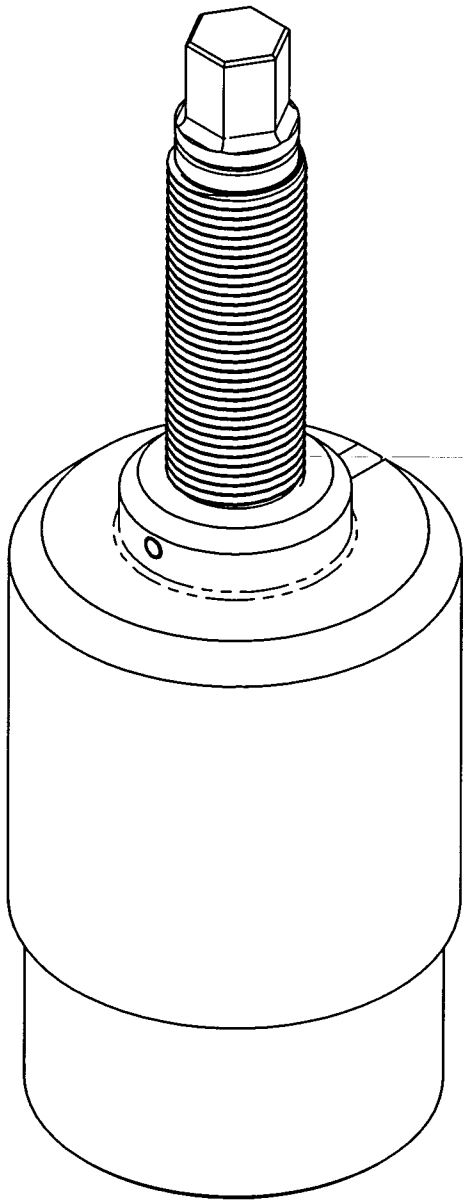
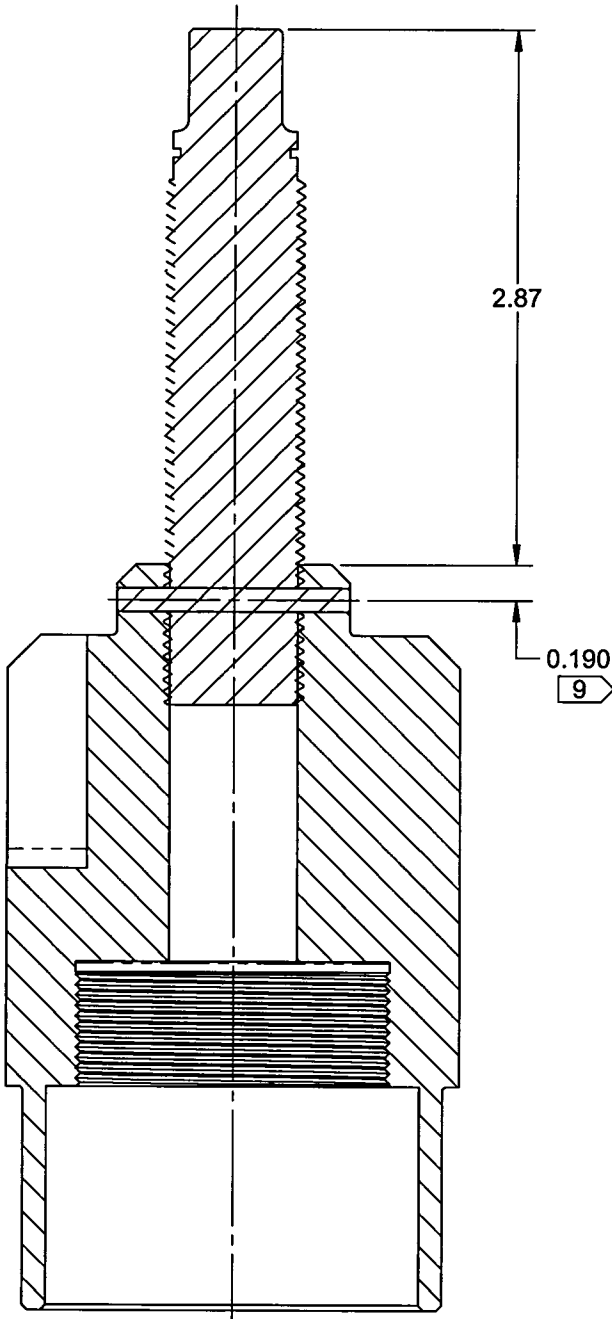
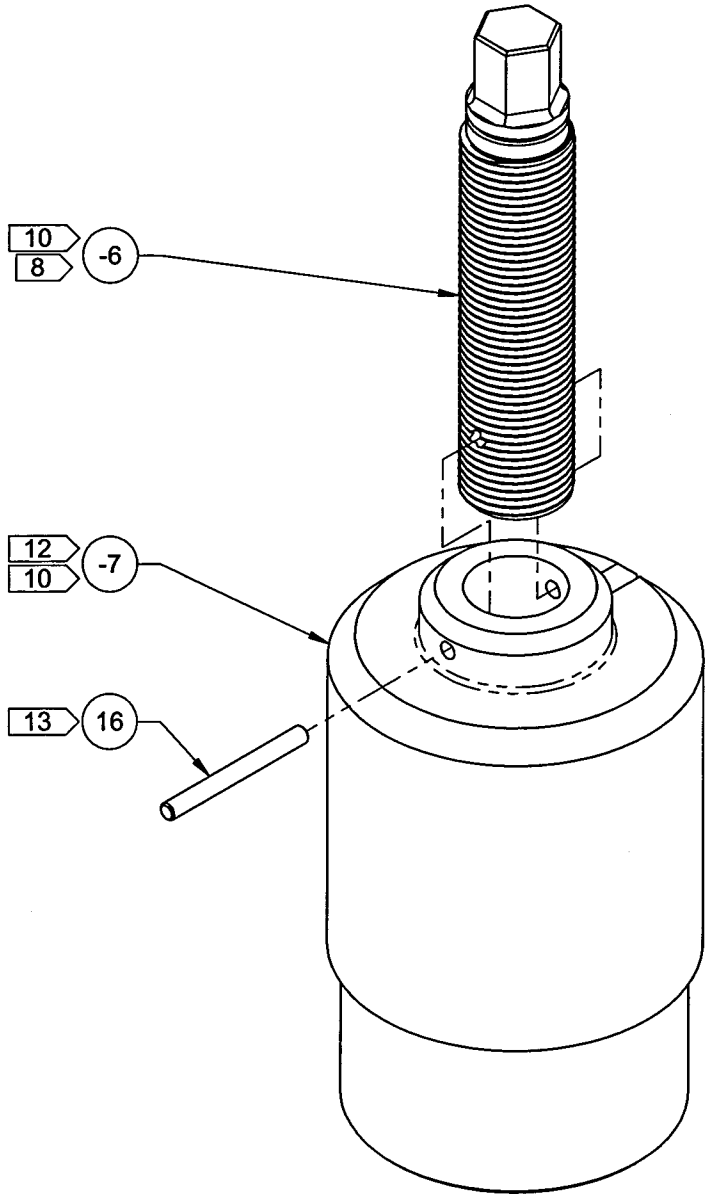
10

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) DOWEL PIN IN ITEM -8 MUST BE ALIGNED WITH THE SLOT OF ITEM -5 AS SHOWN
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 5 OF 10
APPROVED	VM	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10305-041-6	THREADED ROD
-7	1	RB 92700-10305-041-7	PUSHER
16	1	McMaster#98381A477 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 1-1/4" LG.

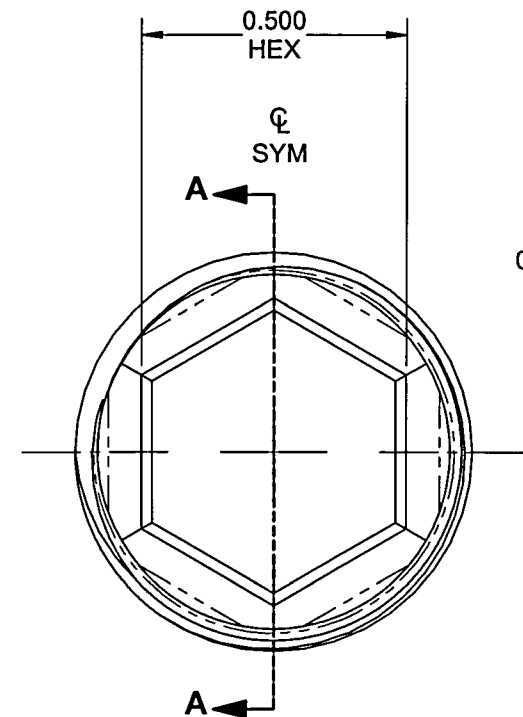
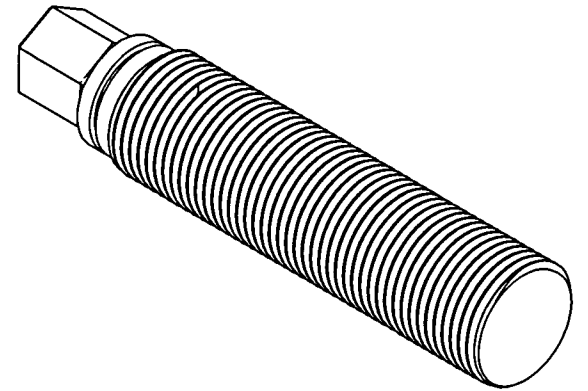


RB 92700-10305-041-5 PUSHER ASSY

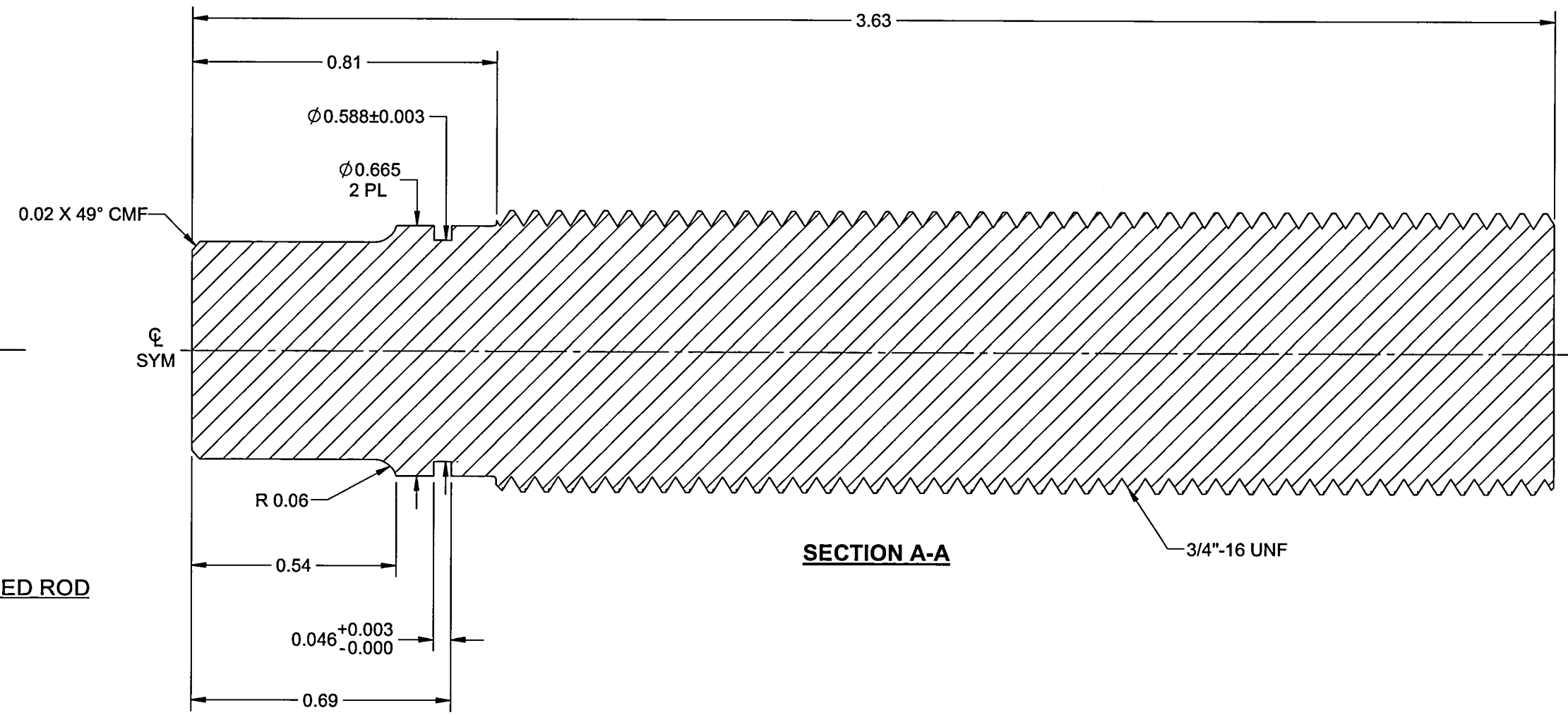
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) INSTALL ITEM -6 AS SHOWN
 - 9) DRILL Ø0.1250"/0.1242" THRU ALL HOLE
 - 10) REMOVE ITEM -6 FROM ITEM -7 AND DEBURR HOLES
 - 11) FINISH MUST BE APPLIED WHEN COMPONENTS ARE UNASSEMBLED
 - 12) APPLY LOCTITE 262/623 TO MATING THREADS OF ITEM -7 THEN REINSTALL ITEM -6 INTO ITEM -7 UNTIL DOWEL PIN HOLE IS ALIGNED
 - 13) APPLY LOCTITE 620 ONTO MATING SURFACES OF ITEM 16 AND ITEM -7 THEN PRESS FIT ITEM 16 INTO HOLE, UNTIL FLUSH WITH SURFACE AS SHOWN

UNDER REVIEW
ECR: ECR 426

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 6 OF 10
APPROVED	W	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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RB 92700-10305-041-6 THREADED ROD

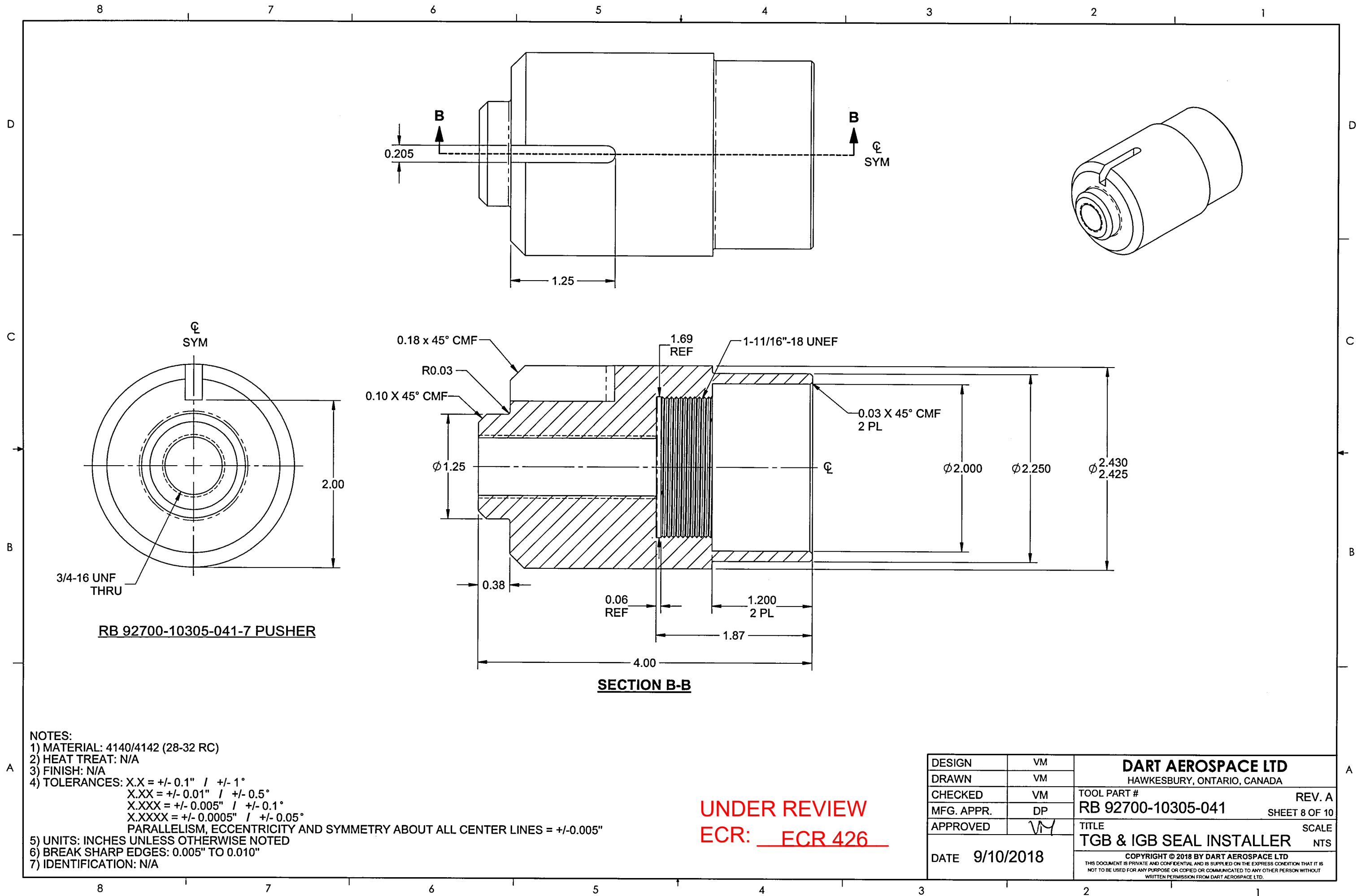


SECTION A-A

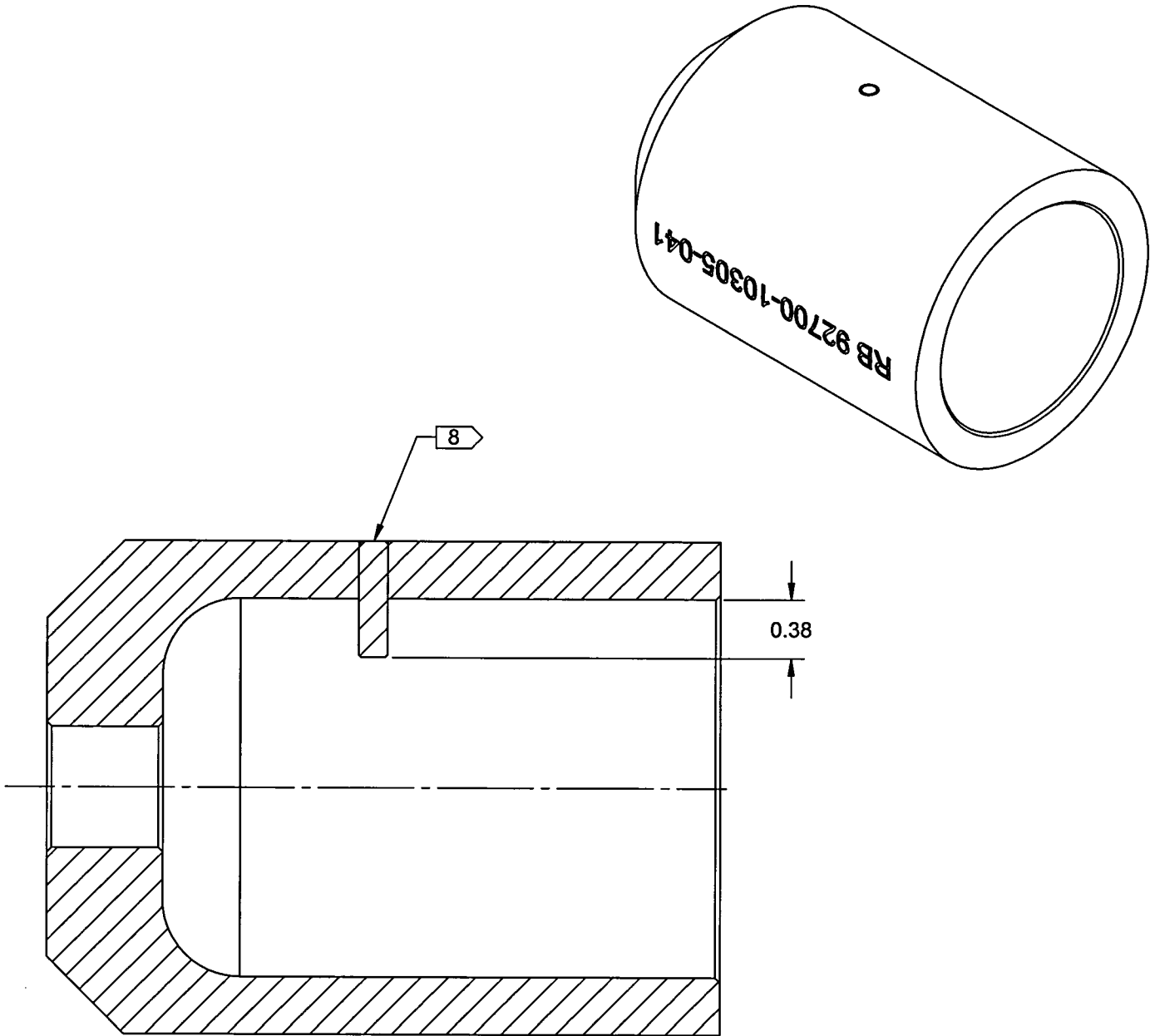
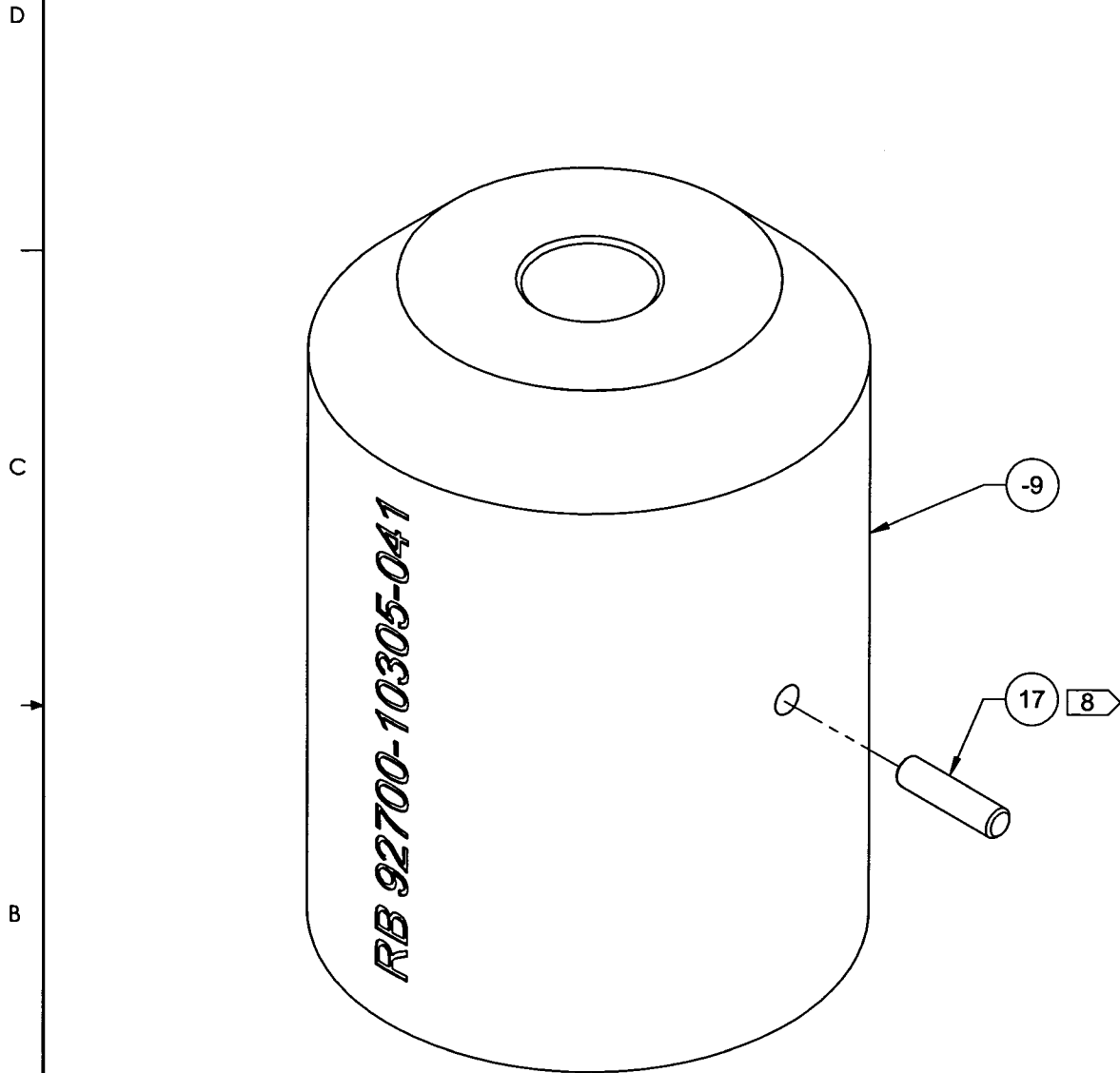
NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

UNDER REVIEW
ECR: ECR 426

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 7 OF 10
APPROVED	VP	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-9	1	RB 92700-10305-041-9	REACTOR
17	1	McMaster#98381A316 OR EQUIV	DOWEL PIN STEEL 3/16" DIA. x 3/4" LG.



RB 92700-10305-041-8 REACTOR ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 17 FLUSH TO THE OUTSIDE OF ITEM -9 AS SHOWN AND REMOVES EXCESS

UNDER REVIEW
ECR: ECR 426

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 9 OF 10
APPROVED	VP	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
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